

Work Order ID 101495 - 2
May-13-13 1:03:08 PM

101495

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 5/13/13

Required Date: 5/31/13

Reference:

Start Qty: 300.00

Req'd Qty: 300.00

Accept

split 25x

300

300

N9000040100

Cust Item ID:

Customer:

Setup Start

NS1

Stop

NS2

Approvals:

Process Plan:

CL

Date: 13/05/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"

Batch:

cut @ meter

0.00

CL 13/05/14 300

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

*issue Photo meter
machine as per dwg D2230-REV.G*

0.00

CL 13/05/14 300

Work Order ID 101495

101495

Page 2

May-13-13 1:03:09 PM

Item ID: D2230-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 5/13/13

Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/31/13

Req'd Qty: 300.00

300

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *used*

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

*used + inspect off
attached cyle to W/O*

0.00

130

QC3- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Hand Finishing

Memo

0.00

125

*SP
135-24*

125

*225
227
228
BS 27*

125 NG 135-30

Work Order ID 101495

101495

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Item ID: D2230-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug

Stop *NS2*

Start Date: 5/13/13

Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/31/13

Req'd Qty: 300.00

300

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00


160

QC

Quality Control

Memo

0.00

125 x 13-5-30. 

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

180

QC3- Inspect Part Finish

0.00

180

QC

Quality Control

Memo

0.00

125 x 13-6-3. 

MI25620

8-45
3200F
9-15

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101495

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Item ID: D2230-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 300.00

300

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/13/13 125

12/6/10

11/3/08-1

Picklist Print

May-13-13 1:03:08 PM

Page 1

Work Order ID: 101495

Parent Item: D2230-3

Parent Item Name: Lug

Start Date: 5/13/13

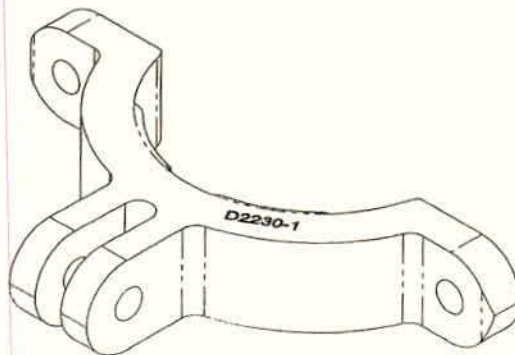
Required Date: 5/31/13

Start Qty: 300.00

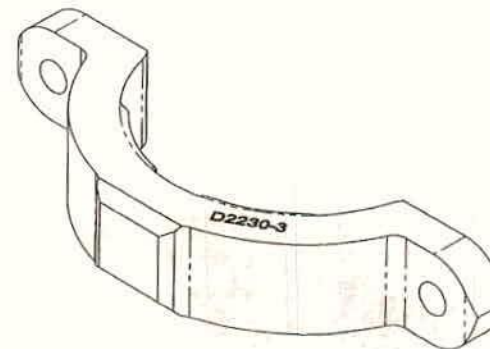
Required Qty: 300.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder
coatEC
BY:EC
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P LUG		Purchased	No				Each	0.0000		300			
D2423 Lug Extrusion		Manufactured	No			100	f	588.7400	0.0683	21.56841		05/13/14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT006		383							
				43722		161.5							
				87953		221.5							
				Metec		205.74							
				93551		205.74				21.57			



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

CL 13/05/14
W/O: 101495

RELEASED
01/06/25/14



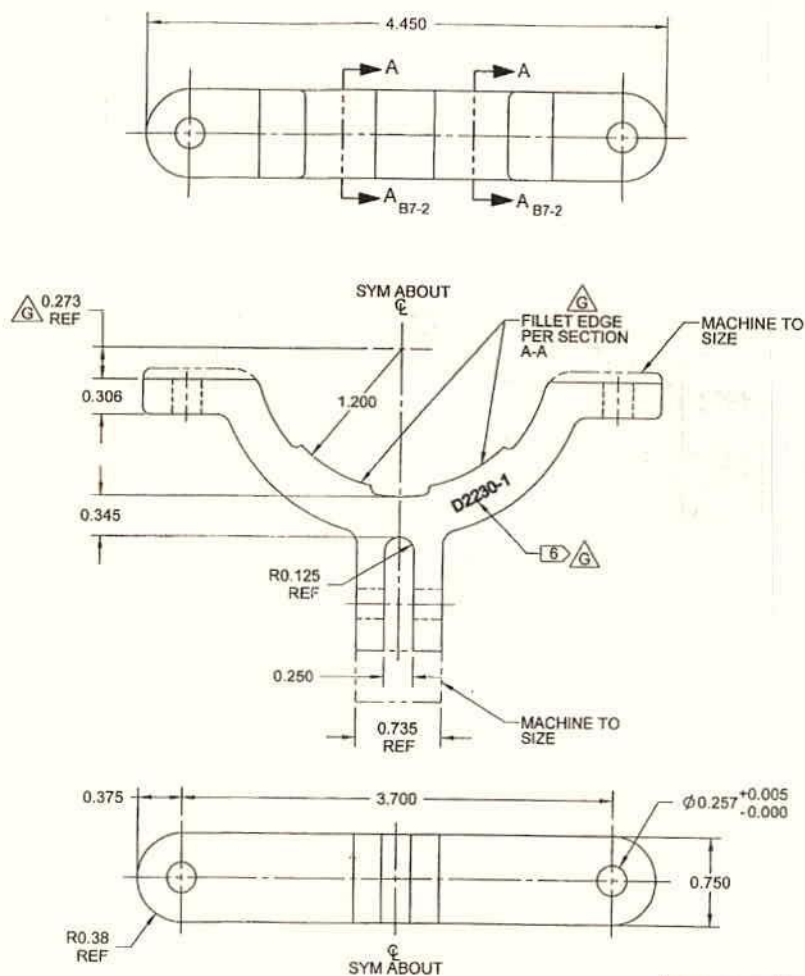
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 \pm 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SECTION A-A D4-2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

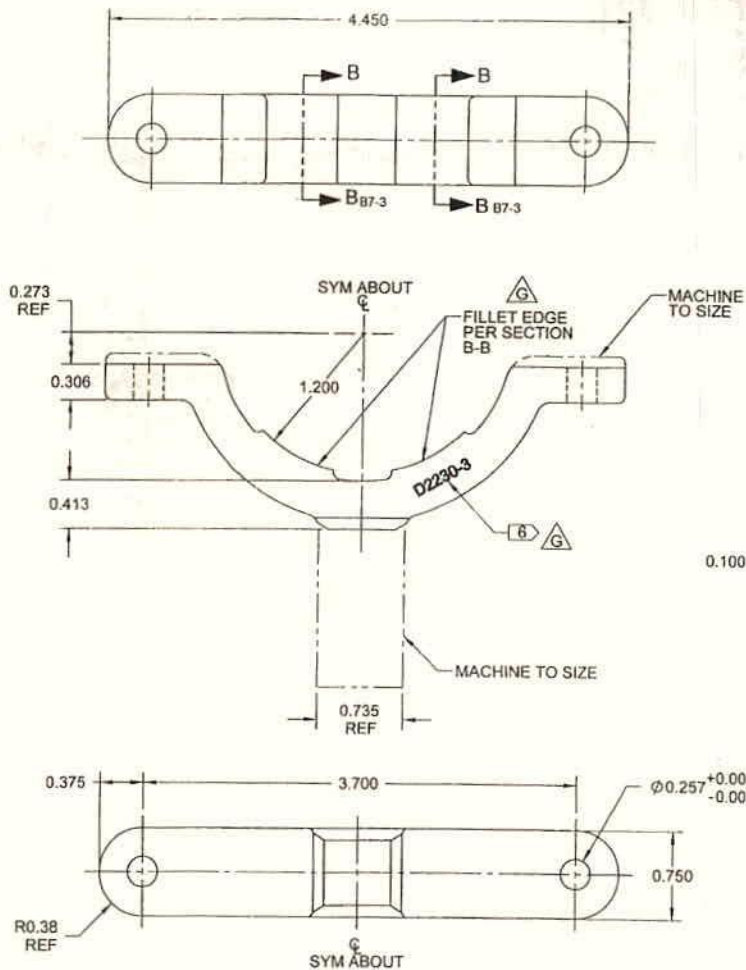
RELEASED
09/06/75

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2014

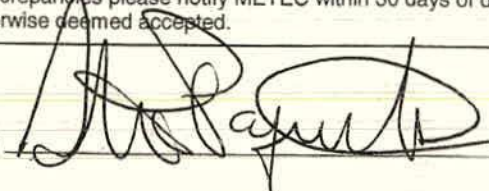
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
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DE APPR.		MOUNTING LUG	NTS
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19232
Date: May 23, 2013
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 19868	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug as per drawing D2230 REV.G , B101450	Each	300		100
D2230-3 Mounting Lug as per drawing D2230 REV.G, B101495	Each	300	125 ✓	175
D2230-1 Mounting Lug as per drawing D2230-1 REV.G, B101834	Each	320		120
D3235-1 Mounting Lug as per drawing D3235-1 REV.A, B101559	Each	200	✓ 100	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by 		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

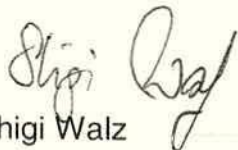
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
125	D2230-3	Mounting Lug	19868
100	D3235-1	Mounting Lug	18986

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 23, 2013



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO19868**

Purchase Order Date 5/13/2013

PO Print Date 5/14/2013

Page Number 1 of 2

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FA
6/13/14

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D2230-3P	LUG	5/17/2013 Yes	300.00 Each	Dart Truck	\$13.6000	\$4.0800
					Net 200		
2	D2230-3P	LUG	Special Inst: AS PER DWG D2230 REV. G B101450 5/20/2013 Yes	300.00 Each	Dart Truck	\$13.6000	\$4.0800
					Net 125		
					SP13-S-24		
3	D2230-1P	LUG	Special Inst: AS PER DWG D2230 REV. G B101495 5/17/2013 Yes	320.00 Each	Dart Truck	\$18.9500	\$6.0640
					Net 200		
4	D3235-1P	lug	Special Inst: AS PER DWG D2230 REV. G B101834 5/17/2013 Yes	200.00 Each	Dart Truck	\$15.0500	\$3.0100
					Net 100		
					Recu 100		
					SP13		

Change Nbr: 2

Change Date: 5/14/2013

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO